

Work Order ID 135491

135491

Page 1

Wednesday, August 12, 2015 4:56:20 PM

Item ID: D3809-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Sliding Block
 Start Date: 8/12/15 Start Qty: 2.00 ***2*** Cust Item ID:
 Required Date: 8/12/15 Req'd Qty: 2.00 ***2*** Customer:
 Reference:

Approvals: Process Plan: MCS Date: AUG 14 2015 Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____
 Run Start ***NR1***
 Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3809	Rev A								

100 0.00
100 SHEAR 8 SL/5-10-5
 Shear Memo 0.00
 Shear Cut Blanks 1.850" long

110 0.01
110 HAAS CNC VERTICAL MACHINING #1 8 SL/5-10-6
 HAAS 1 Memo 0.01
 HAAS CNC vertical machine #1 1- Mill as per Folio FA770 Rev: AA & Dwg D3809 Rev: A 2-Deburr
 per dwg D3809

120 0.00
120 QC2- Inspect parts off machine FAJ/FAIB 8 SL/5-10-6
 QC Memo 0.00
 Quality Control

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC8- Inspect parts - second check	0.00							
130						8	Ø		JFL 2015-10-06
QC	Memo	0.00							
Quality Control									
140	Identify as per dwg & Stock Location: <u>SA/ST</u>	0.00							
140						8		OCT 08 2015	DAS
Packaging	Memo	0.00							CS
Packaging									9-03
150	QC21- Final Inspection - Work Order Release	0.00							
150						MLS		OCT 08 2015	
QC	Memo	0.00							
Quality Control									

SA/ST 20151008

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order update only ☐

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Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation			Disposition		
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			Lead hand / Supervisor Approval Verification		
			QC / QA Coordinator Approval		
Root Cause		FAULT CATEGORY			
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OTHER : _____					

Picklist Print

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Work Order ID: 135491

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Parent Item: D3809-1

D3809-1

Parent Item Name: Sliding Block

Start Date: 8/12/15

Required Date: 8/12/15

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A nEW iSSUE 08-08-01 JLM

Verified By:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MDELRLINB0.250X01.0 00		Purchased	No			100	f	32.5000	0.15	0.31579			

MDFI RINB0 250X01 000

Delrin Bar 0.25" x 1.0"

102

SL 15-10-5

Location

Loc Qty

Loc Code

MAT011

32.5

m129844

32.5

1.25

DQA: _____ Date: _____

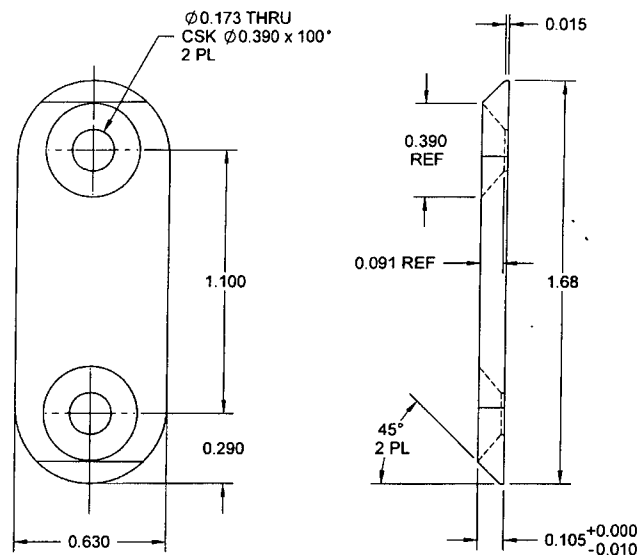


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D3809-1 SLIDING BLOCK
SCALE 2X

NOTES:

- 1) MATERIAL: BLACK DELRIN II 150E OR ACETRON GP ACETAL SHEET OR BAR (REF. DART SPEC. M-DELIN-S OR M-DELIN-B)
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.004 lbs

SHOP COPY
RETURN
ENGINEER
UNCONTROLLED
SUBJECT TO
WITHOUT
WORK OR
NO. 135491 M.C.S.

15 08 14

RELEASED
08-07-24

REV.	A	NEW ISSUE	RF	08.07.24
DESIGN	RF	DESCRIPTION	BY	DATE
DRAWN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
CHECKED	RF	DRAWING NO.	REV. A	
MFG. APPR.	RF	D3809	SHEET 1 OF 1	
APPROVED	RF	TITLE	SCALE	
DE APPR.	RF	SLIDING BLOCK	NTS	
DATE	08.07.24	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.		